

# Work Order ID 56903

March 12, 2010 1:25:53 PM



Page 1

Item ID: D3785-3

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 12/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *PL*  
QC: \_\_\_\_\_

Date: *10-3-12* Tooling: \_\_\_\_\_  
Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw' Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3785	RevD								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3785 Dwg Rev: <i>D</i> Prog Rev: <i>D</i> ****grain direction 45 degree**** 2- Deburr if necessary								<i>PL 10-3-16</i>
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	Memo	0.00							
QC									
Quality Control									<i>LR 10-3-16</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

SB 12/03/17

Draw  
Number

0.00

Draw  
Rev.

0.00

Plan  
Code

0.00

Accept  
Qty

0.00

Reject  
Qty

0.00

Reject  
Number

0.00

Insp.  
Stamp

0.00

(N1)

Pb -&gt;

130



Brake NC

Brake NC

NC BRAKE

0.00

SB 12/03/17

10

Pb →

0.00

Memo

Bend as per Dwg D3785

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10

12/03/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/03/17	170	Took Qty +1 For inspection template	S	10/03/17	4	<i>S Jasmeen</i>	<i>S 10/03/17</i>

Part No: D3785-3 PAR #: 10-011 Fault Category: Eng-drawing ~~Small fins~~ NCR: Yes No DQA: Yes Date: 10/03/17  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 10/03/24

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/17	170	1 part crack fled To change Radius 170 To .388 radius die. R.C. Rad was not Specified correctly on Eng. drawing. For this bend R.C. Eng drawing.	<u>10/03/17</u> <u>GS1042</u>	Scrap & destroy no Resharpen Qty +1 - Open a PAR to ADD correct Rad for this operation	<u>SJ</u> <u>10/01/17</u>	<u>10/03/17</u>	<u>10/03/17</u> <u>GS1042</u>	<u>S 10/03/17</u>
						<u>N/A</u>	<u>10/03/17</u>	<u>S 10/03/17</u>

NOTE: Date & initial all entries

# Work Order ID 56903

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Item ID: D3785-3

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Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 12/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

150



Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Small Fab

Small Fab

0.00



Memo

0.00

Small Fab

1-counter sink holes as per dwg D3785

160



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

10/03/18

+10

170



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Hand Finishing

Memo

0.00

10/03/19

X10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 56903

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Item ID: D3785-3

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 12/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

180



QC

Quality Control

Operation  
Description

QC3- Inspect Part Finish

Set Up/  
Run Hours

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

5/10/03/19

(X10)

190



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

0.00

0.00

2) 11/10/03/22

(X10)

✓

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

11/10/3/22 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 56903

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Item ID: D3785-3

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 12/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

210



Packaging

Packaging

Operation  
Description

Identify as per dwg & Stock Location: 88

Set Up/  
Run Hours

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

10/10/2010 3/22 (C)

220



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/2010 (J)

10-3-2010 (J)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 12, 2010 1:26:11 PM

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Work Order ID: 56903



Parent Item: D3785-3



Parent Item Name: Bracket

Start Date: 12/03/2010

Required Date: 26/03/2010

Comments: IPP Rev:A 08-05-01 new issue DD verified by:EC  
IPP Rev:B 09-01-09 rev.B as per dwg DD verified by:ec

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080			No			100	sf	111.7997	3.1389	3.8		

6061-T6 .080 Sheet

B10-3-16

(b)

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	111.79967	
110630	35.0136	
112141	0.86727	
112763	0.19	
113438	75.7288	113438

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56903
Description: Bracket		Part Number:	D3785-3
Inspection Dwg: D3785	Rev: D		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.006	✓			
6.750	+/-0.010	6.755	✗			
8.500	+/-0.010	8.505	✓			
9.927	+/-0.010	9.930	✗			
0.203	+/-0.010	.206	✗			
0.405	+/-0.010	.409	✗			
5.500	+/-0.010	5.500	✗			
1.500	+/-0.010	1.500	✗			
3.51	+/-0.030	3.569	✗			
3.134	+/-0.010	3.134	✗			
2.259	+/-0.010	2.259	✗			
1.435	+/-0.010	1.434	✗			
1.255	+/-0.010	1.256	✗			
1.427	+/-0.010	1.429	✗			
Ø0.391	+0.006/-0.001	.393	✗			
Ø0.201	+0.005/-0.001	.204	✗			
0.080	+/-0.010	.077	✗			

Measured by:	IB	Audited by:	8	Prototype Approval:	N/A
Date:	10-3-16	Date:	10/03/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	
B	10.02.02	Dimensions revised per Dwg Rev D	KJ	10 N

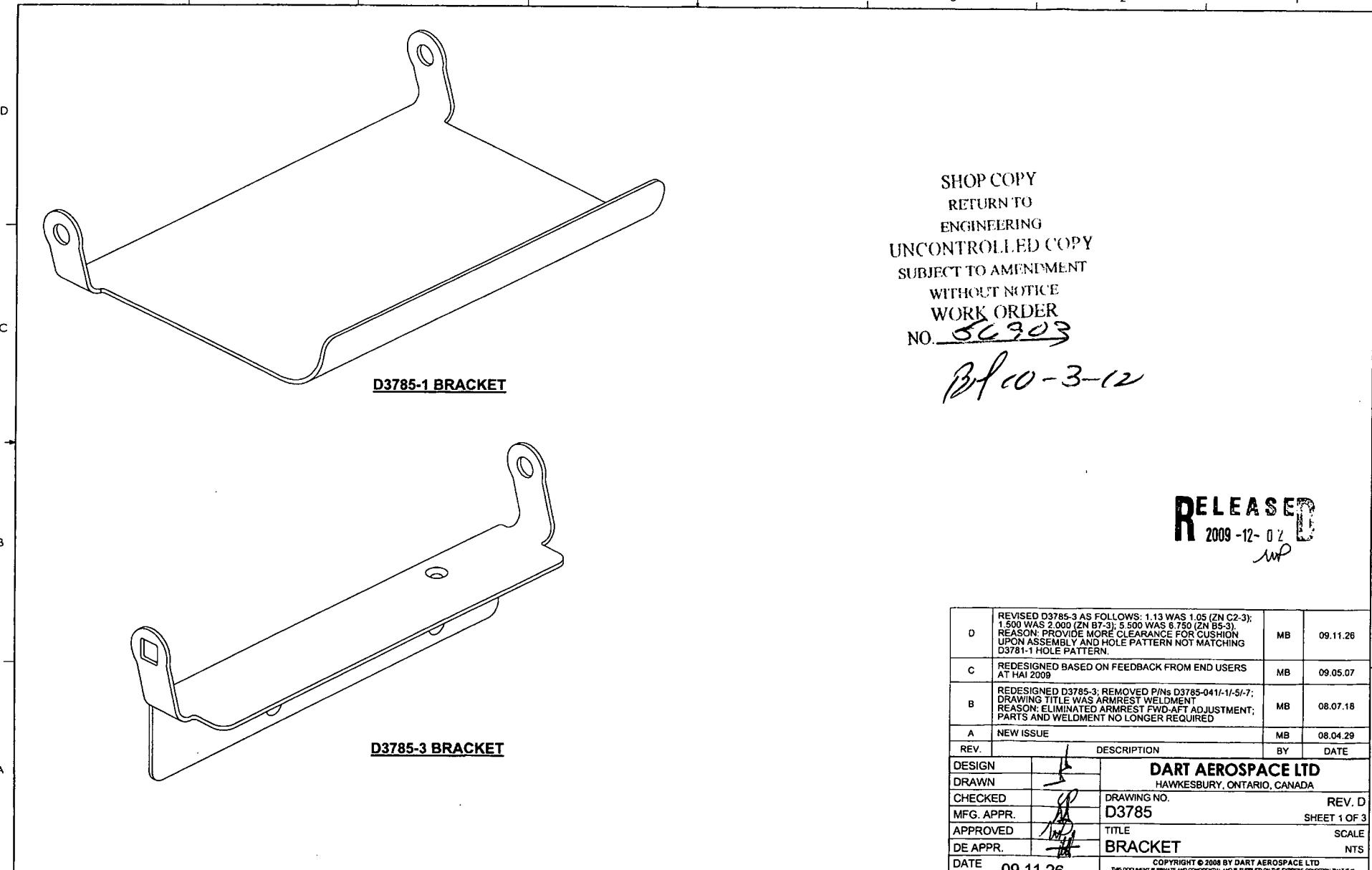
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D	REVISED D3785-3 AS FOLLOWS: 1.13 WAS 1.05 (ZN C2-3); 1.500 WAS 2.000 (ZN B7-3); 5.500 WAS 6.750 (ZN B5-3). REASON: TO PROVIDE MORE CLEARANCE FOR CUSHION UPON ASSEMBLY AND HOLE PATTERN NOT MATCHING D3781-1 HOLE PATTERN.	MB	09.11.26
C	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.07
B	REDESIGNED D3785-3; REMOVED P/Ns D3785-041-1/-5/-7; DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3785	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	09.11.26	COPRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

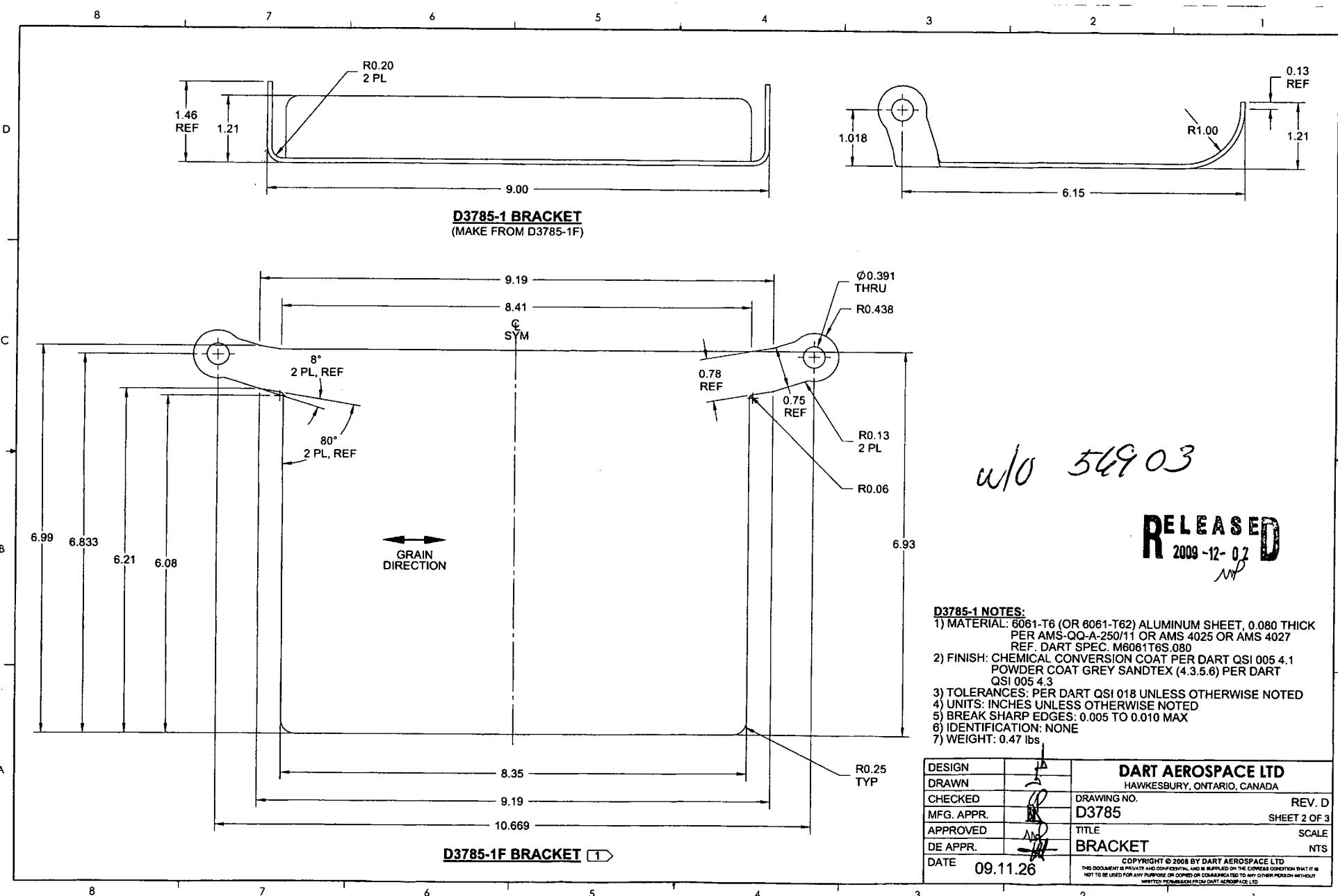
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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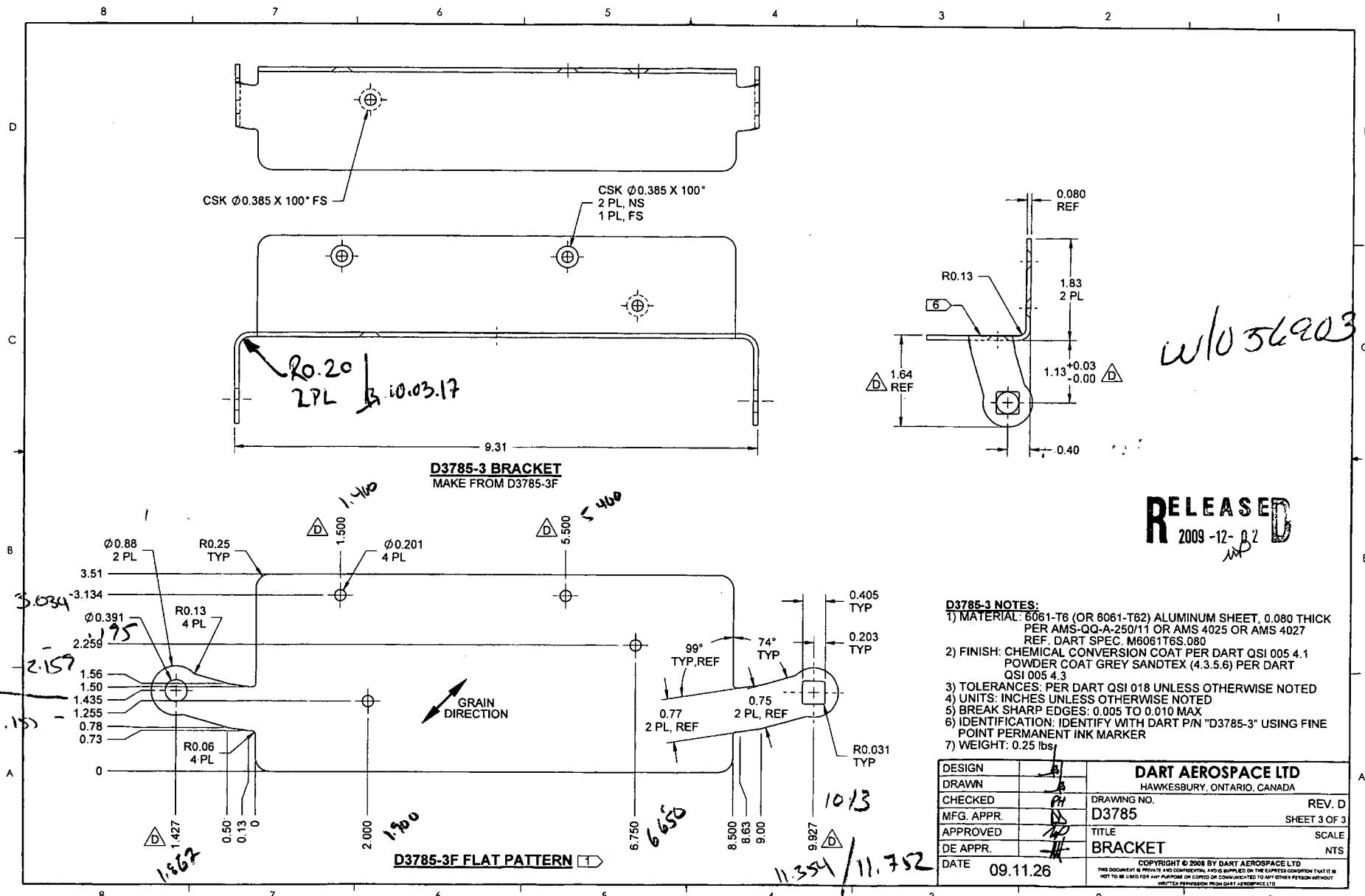


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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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